

Work Order ID 77685-1

\*77685\*

Page 1

Friday, December 16, 2011 12:48:05 PM

Item ID: D3405-043 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Lug Assembly  
 Start Date: 12/16/2011 Start Qty: 8.00 \*8\* Cust Item ID:  
 Required Date: 1/6/2012 Req'd Qty: 8.00 \*8\* Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date: 1/12/16 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3405	Rev B								
100	FLOW WATER JET	0.00							
*100*									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3405								
304.175	Dwg Rev: <i>PB</i>								
	Prog Rev: <i>PB</i>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

B11-12-29

15

B11-12-29

8 4/12/29

415



# Work Order ID 77685

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Friday, December 16, 2011 12:48:05 PM

Item ID: D3405-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Lug Assembly  
 Start Date: 12/16/2011 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 1/6/2012 Req'd Qty: 8.00 **\*8\*** Customer:

## Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Brake NC	NC BRAKE	0.00				(14)	(20)		PTD
Brake NC	Memo 1-Debur 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming	0.00							Sp 12/10/09
140 <b>*140*</b> QC	QC5- Inspect part completeness to step on W/O	0.00				(+14)	(20)		Sp 12/10/09
Quality Control	Memo	0.00							
150 <b>*150*</b> Large Fab	Weld per dwg A/R S.S. rod Batch: <u>M118637</u>	0.00							
Large Fab	Large Fab	0.00							
Large Fab	Memo Weld as per Dwg D3405 use DT8484 Identify as D3405-043	0.00							Q 12-1-24 (X6)





# Work Order ID 77685

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Friday, December 16, 2011 12:48:05 PM

Item ID: D3405-043 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Lug Assembly  
 Start Date: 12/16/2011 Start Qty: 8.00 \*8\* Cust Item ID:  
 Required Date: 1/6/2012 Req'd Qty: 8.00 \*8\* Customer:

Reference: Run Start \*NR1\*  
 Stop \*NR2\*  
 Approvals: Process Plan: Date: Tooling: Date:  
 QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
*160*									
QC	Memo	0.00							
Quality Control									

170	QC5- Inspect part completeness to step on W/O	0.00							
*170*									
QC	Memo	0.00							
Quality Control									

180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
*180*									
Powdercoat	Memo	0.00							
Powder Coating									

START TIME:  
 OVEN TEMPERATURE:  
 FINISH TIME:

1:00  
 400°F  
 1:30

m 119480

6x4 m/12/01/25





# Work Order ID 77685

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Friday, December 16, 2011 12:48:05 PM

Item ID: D3405-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Lug Assembly  
 Start Date: 12/16/2011 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 1/6/2012 Req'd Qty: 8.00 **\*8\*** Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							
200 <b>*200*</b> Packaging Packaging	Identify as per dwg & Stock Location <b>ST478</b>  Memo	0.00  0.00							
210 <b>*210*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

6x of all 12/16/21  
counted & measured

SP 12-01-25

12/1/26

12-01-24  
(4)





# Picklist Print

Page 1

Friday, December 16, 2011 12:48:09 PM

Work Order ID: 77685

**\*77685\***

Parent Item: D3405-043

**\*D3405-043\***

Parent Item Name: Lug Assembly

Start Date: 12/16/2011

Required Date: 1/6/2012

Start Qty: 8.00

Required Qty: 8.00

## Comments:

IPP A05.09.01New issueKJ/JLM  
IPP B 09.01.28 Rev b dwg EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3404-1

Manufactured

No

100

Each

57.0000

1

8

\*\*

EL 127-24

**\*D3404-1\***

GHW Lug

### Location

### Loc Qty

### Loc Code

WA030

57

70664

7

72326

5

74551

5

76994

40

M304S11GA

Purchased

No

150

sf

61.9000

0.154

1.296842

2.5

\*\*

1B11-12-29

**\*M304S11GA\***

304/316 0.125 Sheet

### Location

### Loc Qty

### Loc Code

MAT020

61.9

119006

32.5

119048

29.4

119006

15





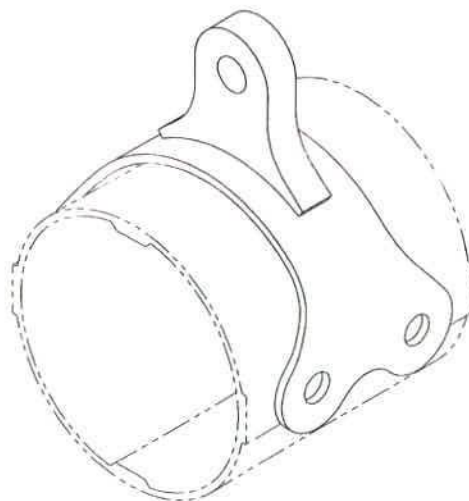




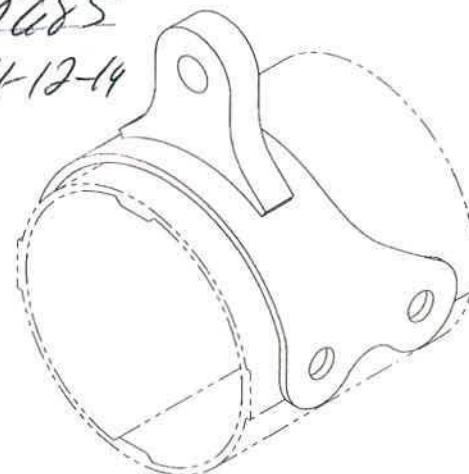
ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

△

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 77685  
R11-12-14



**D3405-041 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)



**D3405-043 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)

**RELEASED**  
08/12/18

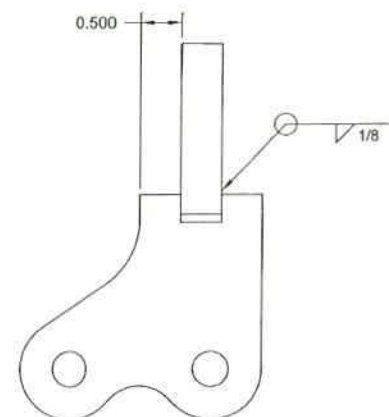
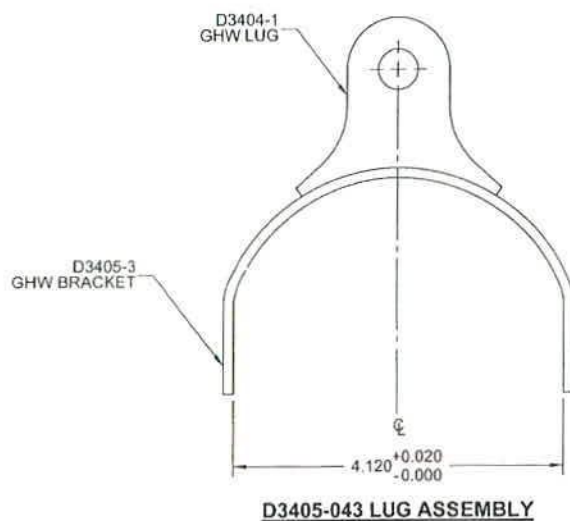
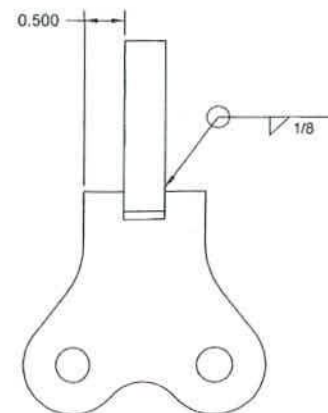
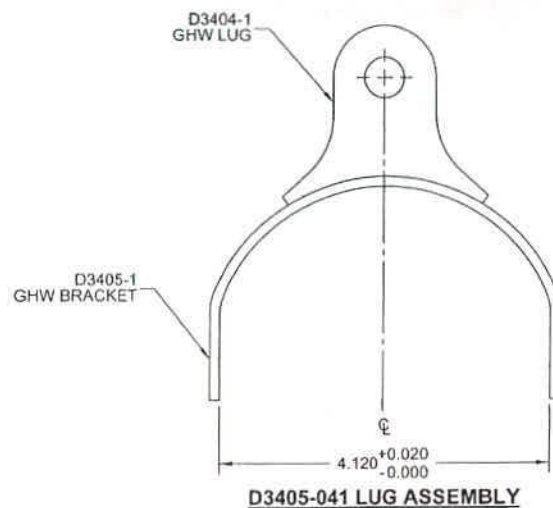
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER  
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs  
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PART 198), SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3405	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG ASSEMBLY	NTS	
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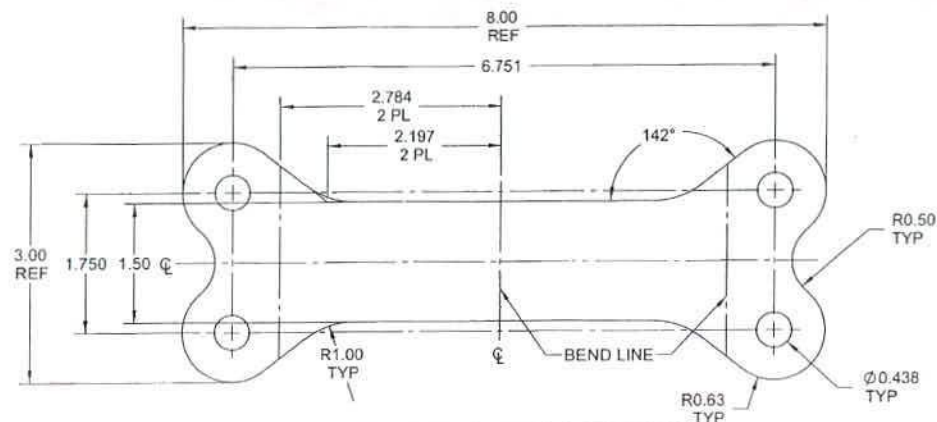


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06/12/18

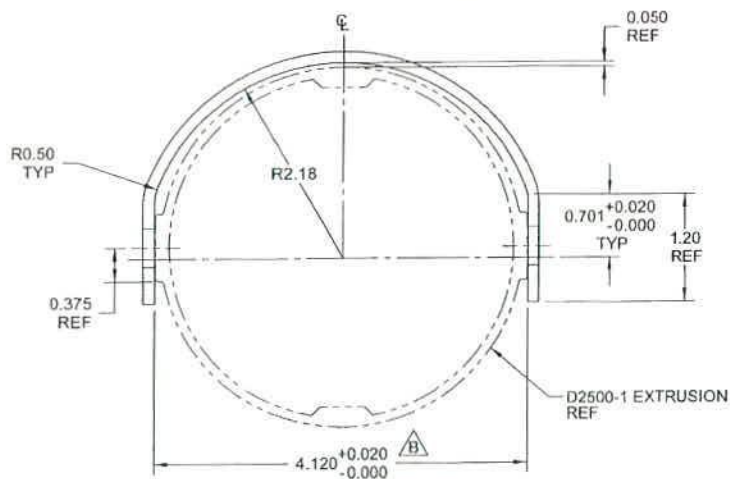
17685

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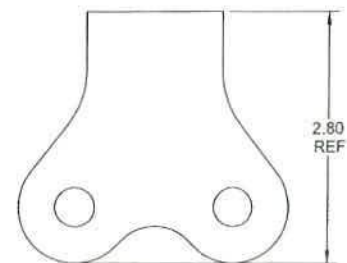




**D3405-1F GHW BRACKET FLAT PATTERN**



**D3405-1 GHW BRACKET**  
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

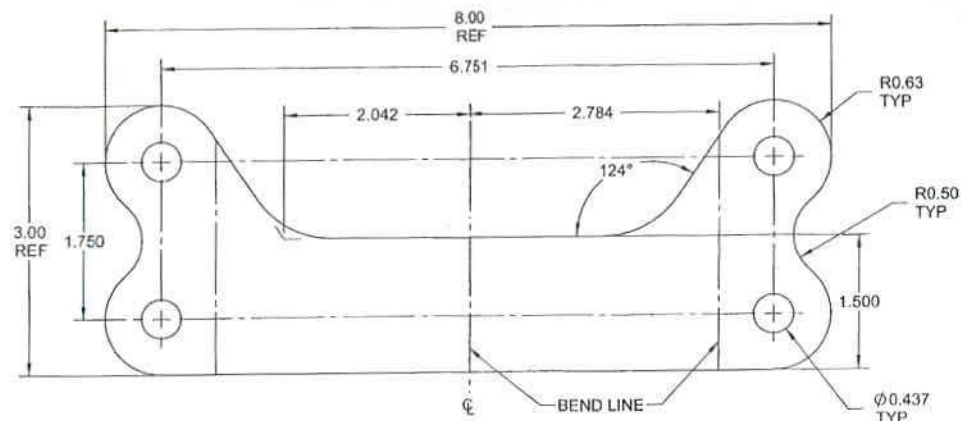
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
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DE APPR.		GHW LUG ASSEMBLY	NTS
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08/09/19

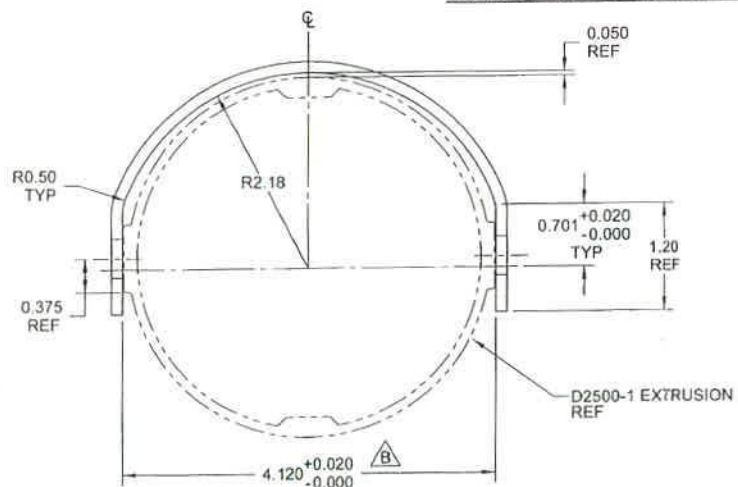
77685



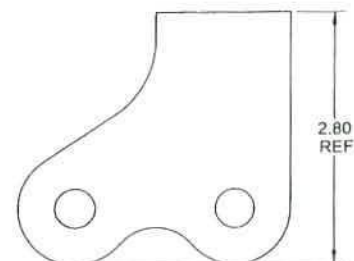




**D3405-3F GHW BRACKET FLAT PATTERN**



**D3405-3 GHW BRACKET**  
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

177685

RELEASED  
08/12/18

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 4 OF 4
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